

Date: Thursday, 29/05/2008 9:50:46 AM
 User: Linda Lacelle

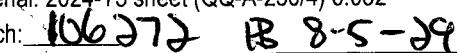
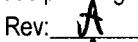
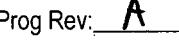
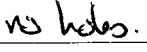
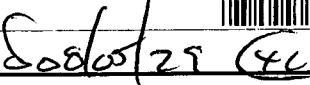
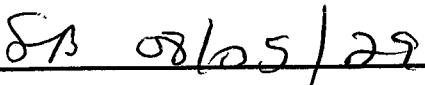
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SEAT PAN		
Job Number	: 37875					
Estimate Number	: 11092					
P.O. Number	:			Part Number	: D30221	
This Issue	: 29/05/2008	S.O. No. :		Drawing Number	: D3022 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: LARGE FAB ASSY		
Previous Run	: 37875			Drawing Revision	: A	
Written By	: 			Material	:	
Checked & Approved By	:			Due Date	: 05/06/2008	
Comment	: Est. C 02.01.23 Revised NG			Qty:	1 Um: Each	
	Est Rev:D 08-04-16 now water jet DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet 
		Comment: Qty.: 1.7044 sf(s)/Unit Total : 1.7044 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" Batch: 
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3022 Dwg Rev:   Prog Rev:  *** grind direction along 31.700" *** 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE 
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK  
5.0	BRAKE NC	NC BRAKE 
		Comment: NC BRAKE 
		1-Form as per Dwg D3022

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 37875

Part Number: D30221

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/06/10

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Transfer drill Seat Pan From Frame
*****Transfer drill in D3022-1 using D3017-041 *****

2-Deburr

PD 08-06-10

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/06/10

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/10 ①

①K

10.0 POWDER COATING

POWDER COATING



M105642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:10

05

OVEN TEMPERATURE: 320

40

FINISH TIME: 1:40

M. 1

08/06/10

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/10 ①

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/06/11

①

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 37875

Part Number: D30221

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/2012

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

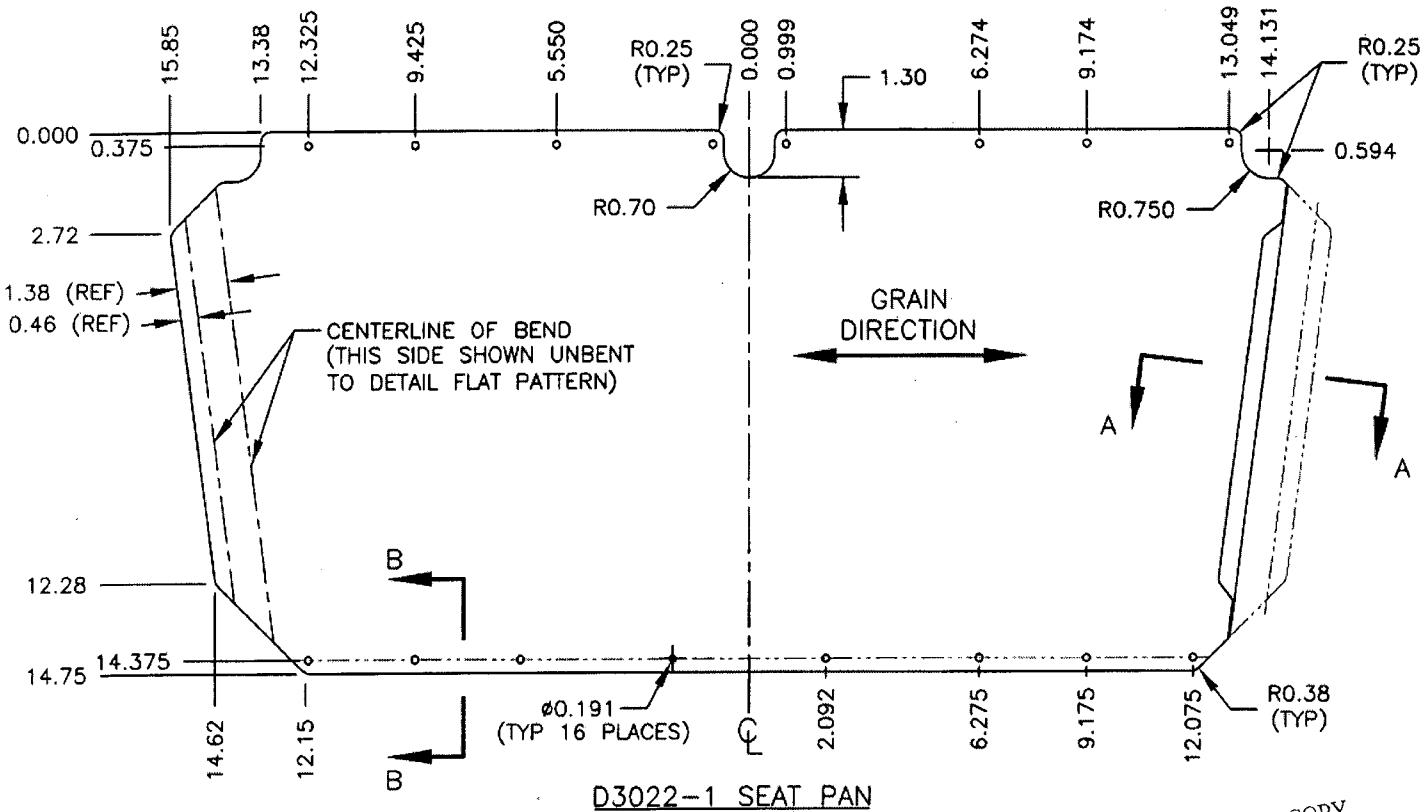


MF 08-06-12

DART

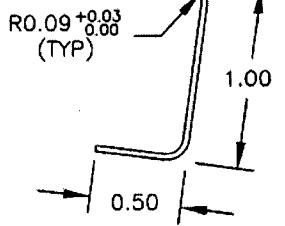
04/04/2018
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3022	SHEET 1 OF 1
DATE		TITLE	SCALE
01.05.18		SEAT PAN	1:5
A	01.05.18	NEW ISSUE	

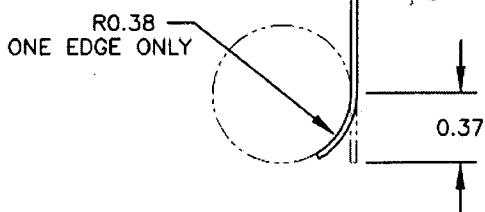


D3022-1 SEAT PAN

SECTION A-A



SECTION B-B



RELEASED
04.06.07

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37875

NOTES:

- 1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD	Work Order:	37875
Description: SEAT PAN	Part Number:	D 3022-1
Inspection Dwg: D 3022 - Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BS
Date:	8-5-29

Audited by:	<i>D. Edwards</i>
Date:	<i>06/05/05</i>

Prototype Approval:	<i>[Signature]</i>
Date:	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	